Work Order ID 117703

May-01-14 7:28:27 AM

117703

Item ID: D4410-7
Revision ID:
Item Name: Conduit
Start Date: 5/01/14 **Start Qty:** 10.00 *10*
Required Date: 5/15/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** MLS **Date:** 14-05-01
QC: _____ **Date:** _____
Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D4410 / Revision Nbr: C									
100		0.00							
100						10			FF 14-05-06
Small Fab	**Memo**	0.00							
Small Fab	BEND AS PER DWG								
	DEBURR								
110	QC5- Inspect part completeness to step on W/O	0.00							
110						10			
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: W/A002	0.00							
120						10	EZ	14-5-8	
Packaging	**Memo**	0.00							
Packaging									

DAS 27 9:58 M/S/T

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

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Accept *N900040100* **Setup Start** *NS1*
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Run Start *NR1*
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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130						MLJ	14-05-09		
QC	**Memo**	0.00							
Quality Control									

14·05·08

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____

Part No. _____

NCR No. _____

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Use-as-is ☐
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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Picklist Print

May-01-14 7:28:31 AM

1

Work Order ID: 117703

117703

Parent Item: D4410-7

D4410-7

Parent Item Name: Conduit

Start Date: 5/01/14 **Required Date:** 5/15/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP REV:A NEW ISSUE 11-11-02 JLM VERIFIED BY:DD IPP
REV:B AS PER PB6 12-08-13 JFS VERIFIED BY:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.625W.049		Purchased	No				f	130.7112		18			
M6061T6T0.625W.049									**		FF	14-05-16	
6061-T6 RD Tube .625 x.049W													

Location	Loc Qty	Loc Code	
MAT014	130.7112		
124069	4		
m127600	126.7112		18

DQA: _____ Date: _____

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
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☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD

Description: Conduit Work Order: 117703

Inspection Drawing: 4410 Rev: C Part Number: D 4410-7

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.81	±0.030	18.81	V		5Fab-07	
10.50	±" "	10.50	V		" " -07	
4.00	±" "	4.00	V		" " -07	
2.00	±" "	2.00	V		" " -07	
2.73	±" "	2.75	V		" " -08	
2.11	±" "	2.11	V		" " -05	
143°	1°	143	V		5Fab-05	

Measured by: FF	Checked By: DAS 30 9-89	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*)
Date 14-05-06	Date 14/05/07	Date 14/5/14	Date